



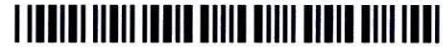
Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship May 24
Order 5782
003424

648.4701

Job Sheet 176646



Part No: 648.4701

Job Qty: 1 ea

Part Name: C2 Overhaul Kit



Part Weight: 0 lbs

Status: Scheduled *A+ Planning*

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 5/24/18

Description:

Note: DWG OM_OOPM-C2 Rev 4 IPP Rev A 18.03.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/24/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Small Fab	1 pcs		5/24/18	0.00	1.00	Small Fab-9		DAS
120	QC	1 pcs		5/24/18	0.00	0.00	QC4		38
125	DC	1 pcs		5/24/18	0.00	0.00	DC		9-89
130	Packaging	1 pcs		5/24/18	0.00	0.00	Packaging3-1		GA/35 18-06-12
140	QC21-FG	1 Ea		5/24/18	0.00	0.00	QC21		DAS 21 18-06-12

Part Op 110 - Pick kit

Descriptions: 125 - Photocopy bluefile & type labels per PPP 648.7401

130 - Identify and pack for shipping as per PPP 648.4701

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4 ✓	Set Screw ✓	2 Ea (2 ea)	90-Start up Operation	5058750
600.1310-AP ✓	Label ✓	1 pcs (1 ea)	90-Start up Operation	5029480
600.1314P ✓	C2 Caution Sticker ✓	1 pcs (1 ea)	90-Start up Operation	5029484
AN3-14A ✓	Bolt ✓	1 Ea (1 ea)	90-Start up Operation	5067270
AN4-16A ✓	Bolt ✓	2 Ea (2 ea)	90-Start up Operation	5068654
AN4-17A ✓	Bolt ✓	1 Ea (1 ea)	90-Start up Operation	5067893
AN960-10 ✓	Washer ✓	1 Ea (1 ea)	90-Start up Operation	5027738
AN960-10L ✓	Washer, #10 ✓	1 Ea (4 ea)	90-Start up Operation	5068663
AN960-416 ✓	Flat Washer Dia 1/4" ✓	6 Ea (6 ea)	90-Start up Operation	5056461
C2-12-1P ✓	Lock Bushing ✓	2 Ea (2 ea)	90-Start up Operation	5029234
C2-12-7P ✓	Teflon Spacer Lock ✓	2 pcs (2 ea)	90-Start up Operation	5029236
C2-12-8 ✓	DUST SHEILD - C2 HOOK ✓	2 Ea (2 ea)	90-Start up Operation	
C2-13-5 ✓	Keeper Spring ✓	1 (1 ea)	90-Start up Operation	5075033
C2-14-2 ✓	Label Rivets ✓	4 Ea (4 ea)	90-Start up Operation	5057170
C2-3-1 ✓	Bearing DU ✓	2 pcs (2 ea)	90-Start up Operation	5068886
C2-3-2-1 ✓	Roller Pin Retaining Ring ✓	2 Ea (2 ea)	90-Start up Operation	5056845
C2-3-3-1 ✓	Latch Roller DU Bearing ✓	1 Ea (1 ea)	90-Start up Operation	5050472
C2-3-5 ✓	Spacer, Teflon ✓	2 Ea (2 ea)	90-Start up Operation	5058758
C2-3-8 ✓	Actuator Bushing ✓	2 Ea (2 ea)	90-Start up Operation	5072543
C2-4-1 ✓	Trunnion Bushing ✓	2 (2 ea)	90-Start up Operation	
C2-7-1P ✓	Load Beam Bumper ✓	1 pcs (1 ea)	90-Start up Operation	5029255
C2-7-2P ✓	Lock Bumper ✓	2 Ea (2 ea)	90-Start up Operation	5029256

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description \	DISPOSITION Rework ☐ Scrap ☐ Use as is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; text-align: center;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td></td> <td></td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
		Supplier ☐																			
		MRB (QSI042) Approval																			
		Completed By																			
		Lead hand / Supervisor Approval Verification																			
		QC / QA Coordinator Approval																			

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DART
AEROSPACE

Container No: S078022

Part: 648.4701

Job No: 176646

Serial No/Batch: S078022

Revision: 4
Inspector: _____
Exp Date: 06/05/2018
Instructions: _____

Date: 06/05/18

Root Cause			
Environment	☐	No Re-verifc	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	Large m Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
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OTHER : _____

C2-9-3 ✓	Clock Spring Cover Screw ✓	4 Ea (4 ea)	90-Start up Operation	5061527
C3-10-2 ✓	Lock Spring ✓	1 Ea (1 ea)	90-Start up Operation	5070352
C3-3-4-1 ✓	Ring, Retaining ✓	4 pcs (4 ea)	90-Start up Operation	5070542
C3-3-9 ✓	Actuator Spring ✓	1 pcs (1 ea)	90-Start up Operation	5029280
C3-8-4 ✓	Solenoid Cover Gasket ✓	1 pcs (1 ea)	90-Start up Operation	5029287
MS21044N4 ✓	Nut, Self-Locking ✓	3 Ea (3 ea)	90-Start up Operation	5061119
MS21083N3 ✓	Nut ✓	3 Ea (3 ea)	90-Start up Operation	5036469
MS35266-63 ✓	Solenoid Cover Screw ✓	1 Ea (1 ea)	90-Start up Operation	5038767
MS35338-137	Washer ✓	4 Ea (4 ea)	90-Start up Operation	5050160

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	2	104	0
	600.1310-AP	1	34	0
	600.1314P	1	60	0
	AN3-14A	1	78	0
	AN4-16A	2	239	0
	AN4-17A	1	163	0
	AN960-10	1	3,363	0
	AN960-10L	4	0	0
	AN960-416	6	0	0
	c2-12-1	2	0	0
	C2-12-7P	2	258	0
	C2-12-8	2	0	0
	C2-13-5	1	0	0
	C2-14-2	4	264	0
	C2-3-1	2	0	0
	C2-3-2-1	2	100	0
	C2-3-3-1	1	29	0
	C2-3-5	2	100	0
	C2-3-8	2	6	0
	C2-4-1	2	0	0
	C2-7-1P	1	119	0
	C2-7-2	2	0	0
	C2-9-3	4	50	0
	C3-10-2	1	0	0
	C3-3-4-1	4	62	0
	C3-3-9	1	0	0
	C3-8-4	1	0	0
	MS21044N4	3	158	0
	MS21083N3	3	87	0
	MS35266-63	1	44	0
	MS35338-137	4	578	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					